

Work Order ID 136757

September 03, 2015 3:25:41 PM

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Page 1

Item ID: D350-607-511 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Quick Release Basket and Long Cargo Tube Mounting Provisions, Fits LH or RH
 Start Date: 9/3/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/30/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: SL Date: 0150904 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-607-4	C								
DSI9699	A								

100 Document Control 0.00 **DAS 6 9-89**
100 DOCUMENT CONTROL
 DC Memo 0.00 **DAS 28 9-89**
 Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPP D350-607-511 CHG006 **NOV 30 2015**

140 Pick Kit 0.00 **DAS 27 9-89**
140 Packaging Memo 0.00 **NOV 25 2015**
 Packaging

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : ☐							

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Item ID: D350-607-511 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
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 Start Date: 9/3/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/30/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC4- 100% Inspect kits for completeness	0.00							
150									
QC	Memo	0.00				IX	DAS 28 9-89		NOV 3 0 2015
Quality Control									
160		0.00							
160	Packaging								
Packaging	Memo	0.00				IX	DAS 28 9-89		NOV 3 0 2015
Packaging	Identify and pack for shipping as per PPP D350-607-511 Location:  PK15A								
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MC5 15-11-30
 MC5 15-11-30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

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Work Order ID: 136757

136757

Parent Item: D350-607-511

D350-607-511

Parent Item Name: Quick Release Basket and Long Cargo Tube Mounting Provisions, Fits LH or RH

Start Date: 9/3/2015

Required Date: 9/30/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 10-06-28 JLM VERIFIED BY: LL IPP
REV:B 13.12.30 PER RE.C ECN13-672 DD VERF:RQ IPP REV:C
14.06.09 AS PER ECN14-572 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3910-7 *D3910-7* Crosstube Lug		Manufactured	No				Each	31.0000		1		DAS 6 9-89	BAS 27 9-89
	DAS 28 9-89			<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST524			30						
				133914			30						
				ST525			1						
				129734			1						
D3501-1 *D3501-1* Bushing		Manufactured	No			140	Each	37.0000	8	8			
									**	135919			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST039			36						
				130742			14						
				131169			22						
				ST046			1						
				125925			1						
D3910-3 *D3910-3* X-Tube Lug		Manufactured	No			140	Each	39.0000	2	2			
									**				
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST523			39						
				117781			39						

NOV 25 2015

NOV 26 2015

NOV 27 2015

NOV 25 2015

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Work Order ID: 136757

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Parent Item: D350-607-511

D350-607-511

Parent Item Name: Quick Release Basket and Long Cargo Tube Mounting Provisions, Fits LH or RH

Start Date: 9/3/2015

Required Date: 9/30/2015

Start Qty: 1.00

Required Qty: 1.00

D4775-041

Manufactured No

140

Each

10.0000

2

2

D4775-041

Strut Assembly

**

137282

DAS 27 9-89

NOV 25 2015

DAS 28 9-89

Location

Loc Qty

Loc Code

ST514

10

132727

2

133493

2

133997

1

135585

5

D4776-3

Manufactured No

140

Each

8.0000

2

2

D4776-3

Skidtube Clevis

**

B 137157X1
B 137658X1

DAS 27 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

ST127

8

133934

8

AN4-14A

Purchased No

140

Each

282.0000

20

20

AN4-14A

Bolt

**

133284

DAS 27 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

FG

5

122141

5

ST325A

200

M132677

100

M133011

100

ST344

77

M132640

77

NOV 26 2015 9-89

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Work Order ID: 136757

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Parent Item: D350-607-511

D350-607-511

Parent Item Name: Quick Release Basket and Long Cargo Tube Mounting Provisions, Fits LH or RH

Start Date: 9/3/2015

Required Date: 9/30/2015

Start Qty: 1.00

Required Qty: 1.00

AN4-42A

Purchased

No

140

Each

52.0000

4

4

~~9-89~~

AN4-42A

Bolt

BAS

27

~~9-89~~

DAS
28
9-89

Location

Loc Qty

Loc Code

ST312A

40

M132551

40

ST342

12

M132317

12

AN6-13A

Purchased

No

140

Each

61.0000

2

2

AN6-13A

BOLT

BAS

27

~~9-89~~

6

~~9-89~~

DAS
28
9-89

Location

Loc Qty

Loc Code

ST286A

50

m132825

50

ST335

11

m132536

11

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Work Order ID: 136757

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Parent Item: D350-607-511

D350-607-511

Parent Item Name: Quick Release Basket and Long Cargo Tube Mounting Provisions, Fits LH or RH

Start Date: 9/3/2015

Required Date: 9/30/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

140

Each

2,170.000

24

24

MS21042L 4

Locknut

133363

BAS

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

112

m127813

112

ST260a

170

m130799

56

m131803

6

m132262

108

ST305

1886

m128300

8

m130388

7

m130922

97

m131618

12

m132123

56

m132382

1706

DAS
6
9-89

MS21042L6

Purchased

No

140

Each

320.0000

2

2

MS21042L 6

Nut

DAS
6
9-89

BAS

27

9-89

NOV 25 2015

DAS
28
9-89

Location

Loc Qty

Loc Code

ST260a

100

m133031

100

ST273A

198

m131624

198

ST305

5

m129909

1

m132262

4

t260a

17

m131317

17

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Shop Packet Print

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Picklist Print

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Work Order ID: 136757

136757

Parent Item: D350-607-511

D350-607-511

Parent Item Name: Quick Release Basket and Long Cargo Tube Mounting Provisions, Fits LH or RH

Start Date: 9/3/2015

Required Date: 9/30/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0432P

Purchased

No

140

Each

950.0000

40

40

NAS1149F0432P

WASHER

BAS

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST260a

500

M132551

500

st268

450

M128995

63

M130388

8

M132677

379

40

DAS

6

9-89

NAS1149F0663P

Purchased

No

140

Each

228.0000

4

4

NAS1149F0663P

WASHER

BAS

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

st268

228

M128591

2

M131317

26

M132823

200

DAS

6

9-89

NOV 25 2015

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607-3 Rev.D,
INSTALLATION INSTRUCTIONS D350-607-4 Rev. C AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607 REV. 6

REF TCCA STC: SH94-14
REF FAA STC: SR00213NY
REF EASA STC: EASA.10016996
REF BRAZILIAN STC: 2007S03-03/-04/-05/-06

1.0 PURPOSE

This service instruction provides parts and instructions to facilitate installation of forward Basket Strut for customers that have purchased: D350-607-501 Conversion Kit @ CHG 004, D350-607-511 Quick Release Basket Mounting Kit @ CHG 004, D350-607-541 @ CHG 006, D350-607-543 @ CHG 007, D350-607-545 @ CHG 006, D350-607-547 @ CHG 007 Heli-Utility-Baskets as well as the D350-607-431 Strut Retrofit Kit and the D350-607-641 Long Cargo Tube @ CHG 001.

2.0 PARTS LIST:

Modify the quantities for D3910-5 and add D3910-7 as follows:

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET @ CHG 007 OR LATER
	X					D350-607-543	HELI-UTILITY-BASKET @ CHG 008 OR LATER
		X				D350-607-545	HELI-UTILITY-BASKET @ CHG 007 OR LATER
			X			D350-607-547	HELI-UTILITY-BASKET @ CHG 005 OR LATER
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
					X	D350-607-501	CONVERSION KIT @ CHG 005 OR LATER
				1	1	D3910-5	X-TUBE LUG
				1	1	D3910-7	X-TUBE LUG

(ADD)

QTY -413	QTY -415	QTY -417	QTY -419	QTY -431	PART NUMBER	DESCRIPTION
X					D350-607-413	HEAVY DUTY LID KIT (LONG)
	X				D350-607-415	HEAVY DUTY LID KIT (SHORT)
		X			D350-607-417	LIGHTWEIGHT LID KIT (LONG)
			X		D350-607-419	LIGHTWEIGHT LID KIT (SHORT)
				X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
				1	D3910-5	X-TUBE LUG
				1	D3910-7	X-TUBE LUG

(ADD)

QTY -641	QTY -611	QTY -511	QTY -431	PART NUMBER	DESCRIPTION
X				D350-607-641	QUICK RELEASE LONG CARGO TUBE
1	X			D350-607-611	LONG CARGO TUBE
1		X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
			X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
		1	1	D3910-5	X-TUBE LUG
		1	1	D3910-7	X-TUBE LUG

(ADD)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.05.16
CERT. NO.: SH94-14
ISSUE NO.: 6

20150904

SH 136857

A	NEW ISSUE	AJS	14.05.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9699	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LUG REPLACEMENT	NTS
DATE	14.05.16	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

3.0 PROCEDURE:

Install the D350-607-501 Conversion Kit, D350-607-511 Quick Release Mounting Kit or D350-607-431 Strut retrofit kit per Installation Instructions D350-607-3 Rev. D or D350-607-4 Rev. C. While installing the Forward Strut perform the following:

3.1 Substitute the Forward Lower D3910-5 X-Tube Lug with the D3910-7 X-Tube Lug as shown in Figure 1.

3.2 Install the forward D4775-041 Strut Assembly. Transfer mark from the upper hole on the clevis of the D4775-041 Strut Assembly to the D3910-7 X-tube Lug and drill thru the lug $\varnothing 0.257$ - $\varnothing 0.261$ as shown in Figure 1. Touch up chemical conversion coating per MIL-DTL-5541. Check the witness holes located at the bottom end of the D4775-041 Strut Assemblies to ensure that the thread from the rod end extends past the witness hole. Torque MS21042L4/-4 nuts to 50-70 in-lbs (5.7-7.9 N-m). Torque MS21042L6/-6 nuts to 160-190 in-lbs (18.1-21.5 N-m).

3.3 Complete the installation in accordance with Installation Instructions D350-607-3 Rev. D or D350-607-4 Rev. C.

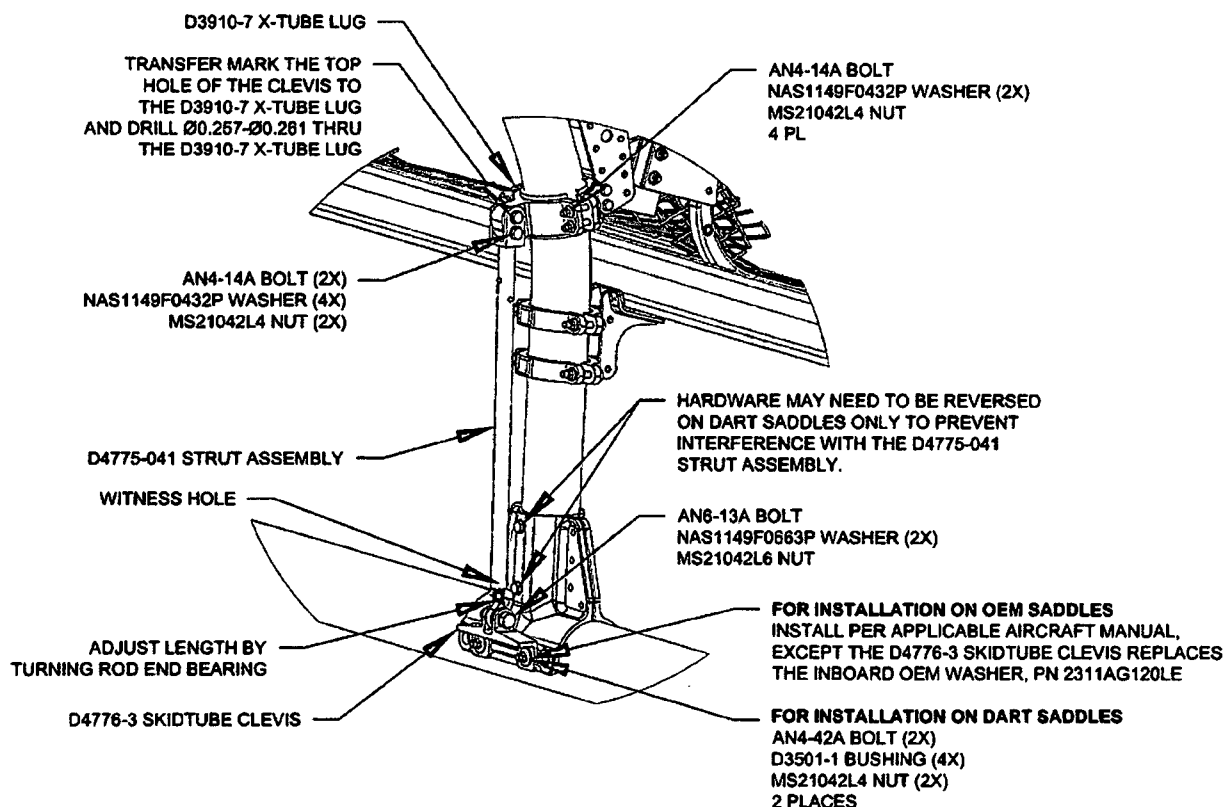


FIGURE 1: INSTALLATION OF D4775-041 FWD STRUT

4.0 WEIGHT AND BALANCE:

There is no weight and balance change associated with this update.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:

D. SHEPHERD (DE # 02)

DATE: 14.05.16
CERT. NO.: SH94-14
ISSUE NO.: 6

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	[Signature]	DRAWING NO. DSI 9699	REV. A
MFG. APPR.	N/A	SHEET 2 OF 2	
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	LUG REPLACEMENT	NTS
DATE	14.05.16	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Item ID: D350-607-511

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Quick Release Basket and Long Cargo Tube Mounting Provisions, Fits LH or RH

Stop ***NS2***Start Date: 9/3/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/30/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: SW Date: 0150904

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D350-607-4

C

DSI9699

A

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D350-607-511 CHG006

MCS 15-11-26

140

Pick Kit

0.00

140

Packaging

Memo

0.00

Packaging